

Ship Monday Oct. 6

Work Order ID 125031

\*125031\*

Page 1

Item ID: D4640-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Floor Protector

Start Date: 10/3/2014 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 10/3/2014 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 14-10-03

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4640

D

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Light Gray Lexan .093"

Memo

0.00

\*\*\*Confirm if parts are trimmed or untrimmed prior to cutting \*\*\*

Cut as per dwg

Prog Rev: D

Dwg Rev: D

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

DAS  
23  
9-89

14-10-8

DAS  
23  
9-89

14-10-8

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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**Work Order ID 125031****\*125031\***

Page 2

Item ID: D4640-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector

Start Date: 10/3/2014 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 10/3/2014 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT  
MARKER ON TEXTURED SIDE

(2)

1

DAS  
38  
9-89 14-10-9

PTO -&gt;

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

PP  
125029

1

DAS  
06  
9-89

OCT 09 2014

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

14/10/10 PJ

ME  
14-10-9

DQA:

Date: 14/12/08



QA Closed:

Date: 14/12/14

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>125031</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D4640-11</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4351</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input checked="" type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14-10-8	100	1	Round mark on 1 pc cut pc from material that was on a skid	DAS 16 9-89	Scrap / destroy no replace	DL 14/10/09	DAS 38 9-89 14-10-8	DAS 16 9-89
Equip/Tooling									
Handling/Pre									
Material									
Operator					Q2242 14/10/09	MLEXS 093-F600607 1129471 \$597			Q2242 14/10/09
Offset/Setup				Re. Operator didn't look the material before taking it and cut it					
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

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# Picklist Print

Friday, October 03, 2014 10:45:53 AM

Page 1

Work Order ID: 125031

\*125031\*

Parent Item: D4640-11

\*D4640-11\*

Parent Item Name: Floor Protector

Start Date: 10/3/2014

Required Date: 10/3/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-07

Purchased

No

100

sf

2,570.313

16

34

\*\*

DAS

23

9-89

14-10-8

\*MI FXS 093-F6006-07\*

GE PLASTICS LEXAN SHEET (Grey)

Location

Loc Qty

Loc Code

MAT023

2570.31332

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

102.33332

m129471

21.92

m129738

1453.95

129471

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Doc/Data									
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Training									
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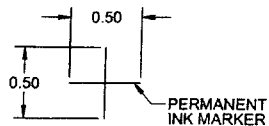
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 125031
<b>Description:</b> Floor Protector		<b>Part Number:</b> D4640-11
<b>Inspection Dwg:</b> D4640	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50"	-		U	Jkmo1
25.42	+/-0.030	25.42"	-		T	Jkmo2
27.86	+/-0.030	27.86"	-		T	
31.36	+/-0.030	31.36"	-		T	
49.96	+/-0.030	49.96"	-		T	
53.46	+/-0.030	53.46"	-		T	
55.90	+/-0.030	55.90"	-		T	
62.11	+/-0.030	62.11"	-		T	
63.61	+/-0.030	63.61"	-		T	
73.08	+/-0.030	73.08"	-		T	
76.55	+/-0.010	76.55"	-		T	
78.05	+/-0.030	78.05"	-		T	
80.80	+/-0.030	80.80"	-		T	
0.88	+/-0.030	0.88"	-		V	
4.21	+/-0.030	4.21"	-		V	
5.02	+/-0.030	5.02"	-		V	
8.59	+/-0.030	8.59"	-		V	
10.65	+/-0.030	10.65"	-		T	
14.22	+/-0.030	14.22"	-		T	
15.03	+/-0.030	15.03"	-		T	
17.62	+/-0.030	17.62"	-		T	
0.37	+/-0.030	0.37"	-		V	
1.84	+/-0.030	1.84"	-		V	
3.67	+/-0.030	3.67"	-		V	
3.76	+/-0.030	3.76"	-		V	
4.59	+/-0.030	4.59"	-		V	
8.59	+/-0.030	8.59"	-		T	
10.65	+/-0.030	10.65"	-		T	
14.64	+/-0.030	14.64"	-		T	
15.48	+/-0.030	15.48"	-		T	
15.57	+/-0.030	15.57"	-		T	
17.40	+/-0.030	17.40"	-		T	
18.87	+/-0.030	18.87"	-		T	
19.24	+/-0.030	19.24"	-		T	
0.093	DAS +/-0.010	0.093"	DAS		V	

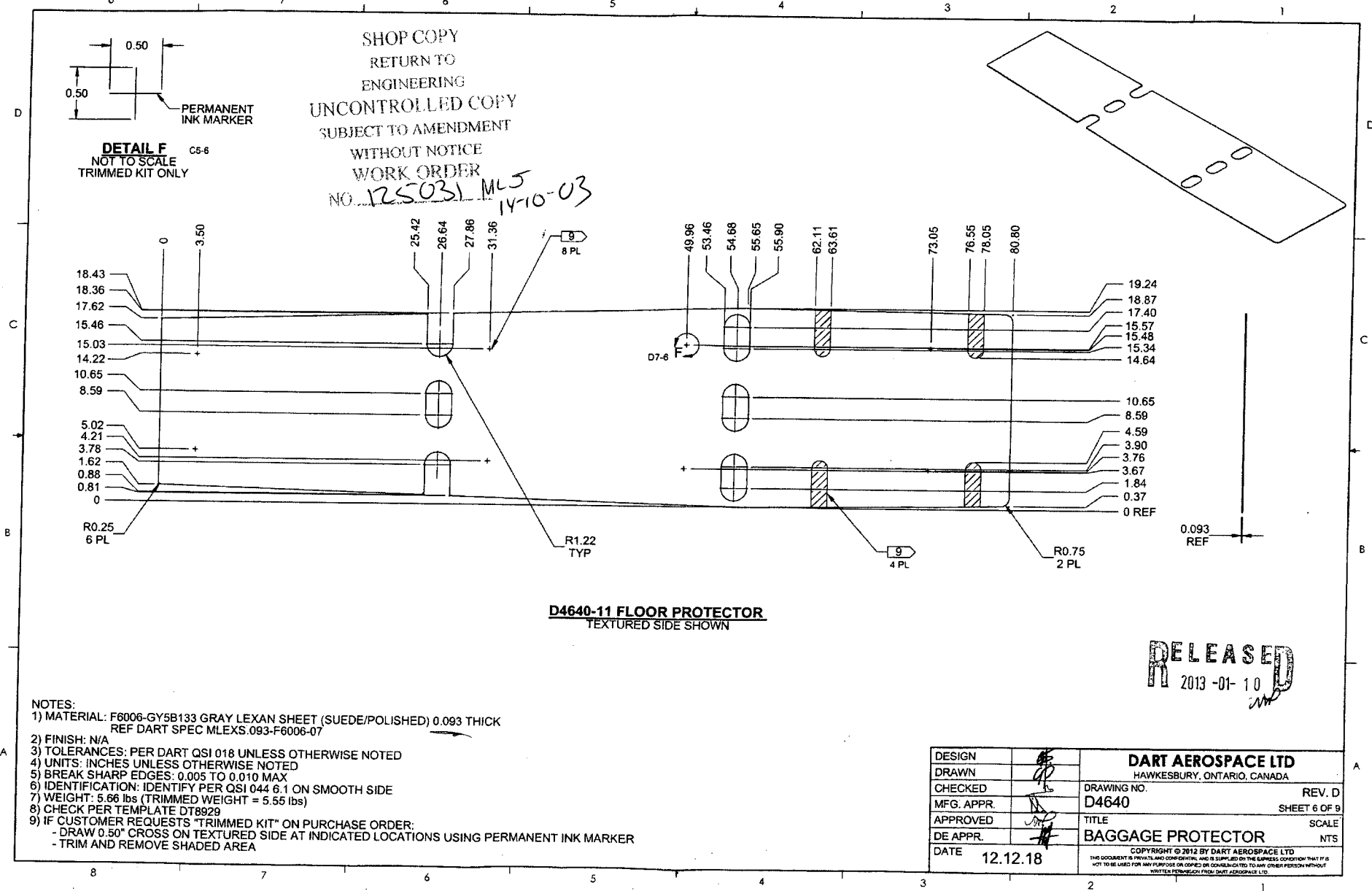
<b>Measured by:</b> 23 9-89	<b>Audited by:</b> 38 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14-10-8	<b>Date:</b> 14-10-9	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 125031 ML5  
14-10-03



**D4640-11 FLOOR PROTECTOR**  
TEXTURED SIDE SHOWN

RELEASED  
2013-01-10

- NOTES:
- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
  - 7) WEIGHT: 5.66 lbs (TRIMMED WEIGHT = 5.55 lbs)
  - 8) CHECK PER TEMPLATE DT8929
  - 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:  
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER  
- TRIM AND REMOVE SHADED AREA

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D4640	SHEET 6 OF 9
MFG. APPR.		TITLE	SCALE
APPROVED		BAGGAGE PROTECTOR	NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.12.18		